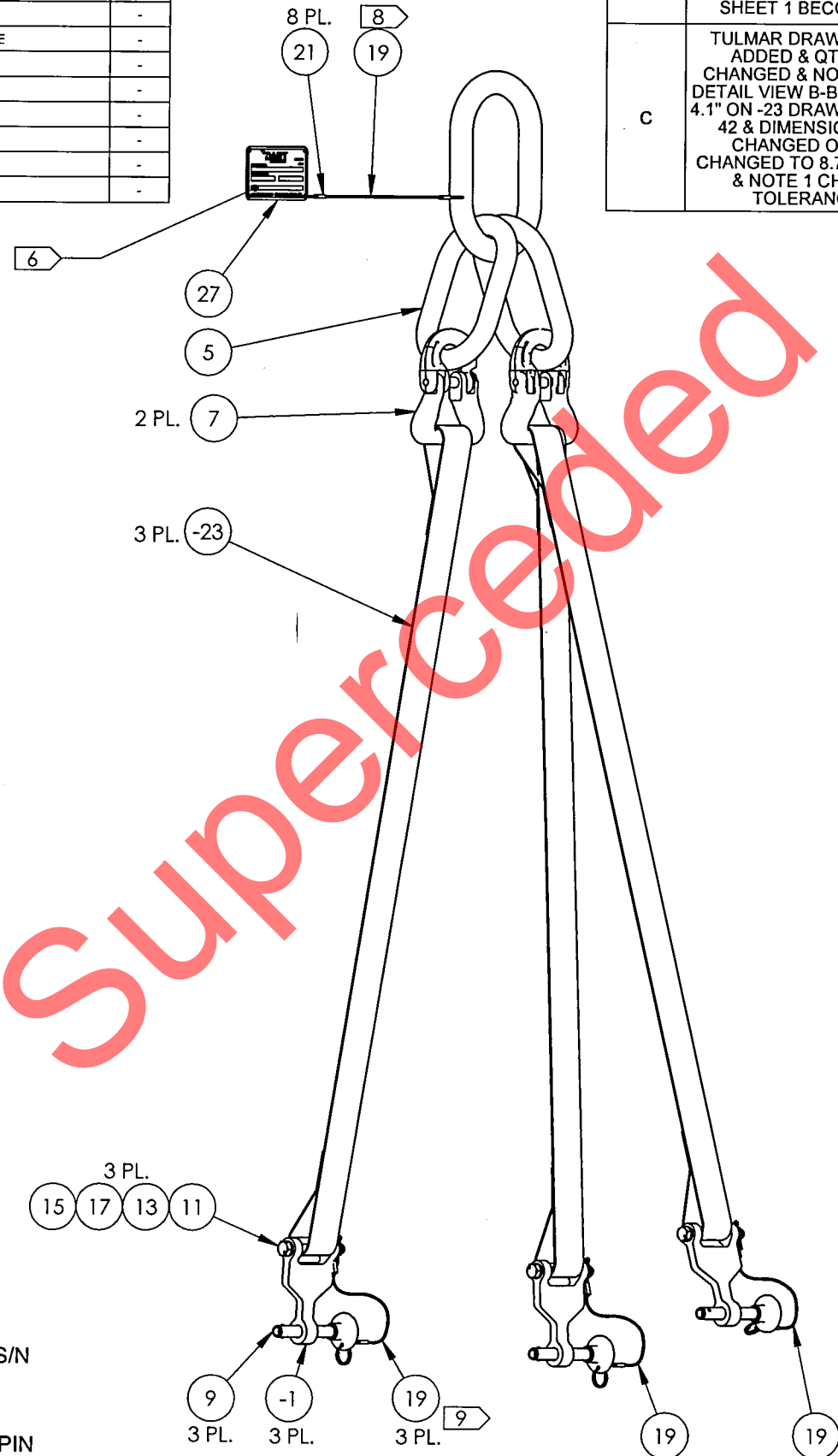


ITEM #	QTY	PART #	TITLE	PG
-1	3	RBEM623U1002102-1	LIFTING CLEVIS	2
-23	3	RBEM623U1002102-23	STRAP ASSY	3
27	1	RB41011	DART PLACARD	-
5	1	McMaster#7163T12	OBLONG LINK W/COUPLINGS LINKS 7/8" GRADE 100	-
7	3	PEWAG#CARW 10 OR CROSBY S-237#1020695	SLING CONNECTOR	-
9	3	McMaster#90985A335	QUICK RELEASE PIN 7/16" x 2-1/2" USABLE	-
11	3	SPENCER AIRCRAFT# AN5-27	HEX HEAD CAP SCREW	-
13	6	SPENCER AIRCRAFT# AN960-516	FLAT WASHER	-
15	3	SPENCER AIRCRAFT# AN310-5	CASTLE NUT	-
17	3	McMaster#98338A175	COTTER PIN 1/8" x 3/4"	-
19	A/R	CARR LANE#CL-2-C	NYLON COATED WIRE 1/16"	-
21	8	McMaster#3896T31	FERRULE 1/16" DIA. x 3/8"	-


REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASE FOR PRODUCTION	-	1/7/2016	RJC	JAG
B	ITEM# -23 ASSY ADDED, MATERIAL SPECIFICATION ADDED TO ITEM# -3, TEMPLATE UPDATED, ITEM# -25 ADDED, WEIGHT TEST DRAWING ADDED ON SHEET 7, PLACARD DRAWING ADDED ON SHEET 6, NOTE 3 ON SHEET 1 BECOME NOTE 7 AND TYPO CORRECTED	17-702	17.10.06	VM	WM
C	TULMAR DRAWING'S MARKUPS ADDED; TULMAR P/N ADDED & QTY OF -25 CHANGED TO 4 & NOTE 10 CHANGED & NOTE 11 ADDED & SECTION A-A ADDED & DETAIL VIEW B-B ADDED & LENGTH OF -25 INCREASE TO 4.1" ON -23 DRAWING, DIMENSION OF 44.9 DECREASE TO 42 & DIMENSION OF .06 CHANGED TO .05 & NOTE 1 CHANGED ON -3 DRAWING, DIMENSION OF 12.5 CHANGED TO 8.75 & DIMENSION OF .2 CHANGED TO .05 & NOTE 1 CHANGED ON -25 DRAWING, TULMAR TOLERANCE ADDED, -26 DRAWING ADDED	17-756	17.11.22	VM	WM

RBEM623U1002102 SWASHPLATE SLING

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: ENGRAVE "SWL 75 LBS, LOAD TESTED 90 LBS" & P/N & S/N WHERE INDICATED
 - 7) REF. AIRBUS T/N M632U1002102
 - 8) ATTACH ITEM# 19 LANYARD TO ITEM# 5 AND ITEM #27 DART PLACARD
 - 9) ATTACH ITEM# 19 LANYARD TO -17 COTTER PIN AND -9 QUICK RELEASE PIN



UNDER REVIEW
URF 17-778 VM



DART
AEROSPACE

Hawkesbury, Ontario, Canada

TITLE

SWASHPLATE SLING

DWG NO.

RBEM623U1002102

REV

C

DESIGN BY:

VM 10/6/2017

DRAWN BY:

VM 11/28/2017

CHECKED:

WM 11/28/2017

MFG. APPR:

DP 11/29/2017

APPROVED:

WM 11/29/2017

DATE:

11/28/2017

SCALE:

NTS

WEIGHT:

N/A

SHEET 1 OF 7

XXX ± .005 FRACTIONS ± 1/8

XX ± .01 ANGLES ± 5°

X ± .1 SURFACES = 125

1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED

2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009

3. DIMENSIONAL LIMITS APPLY AFTER PLATING

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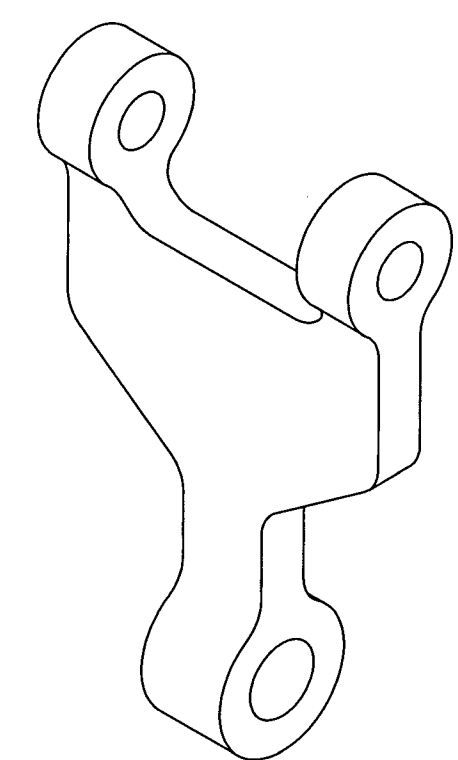
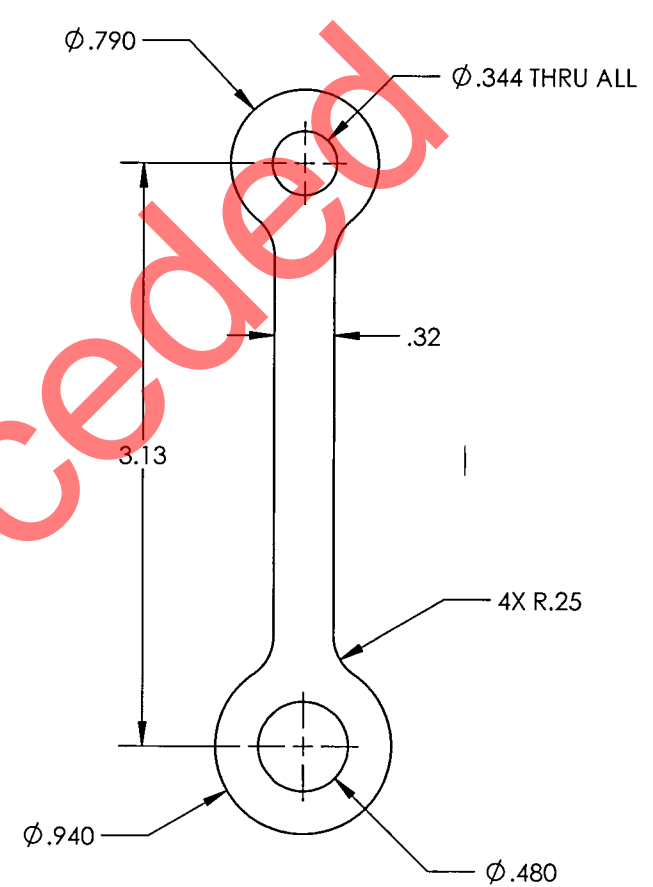
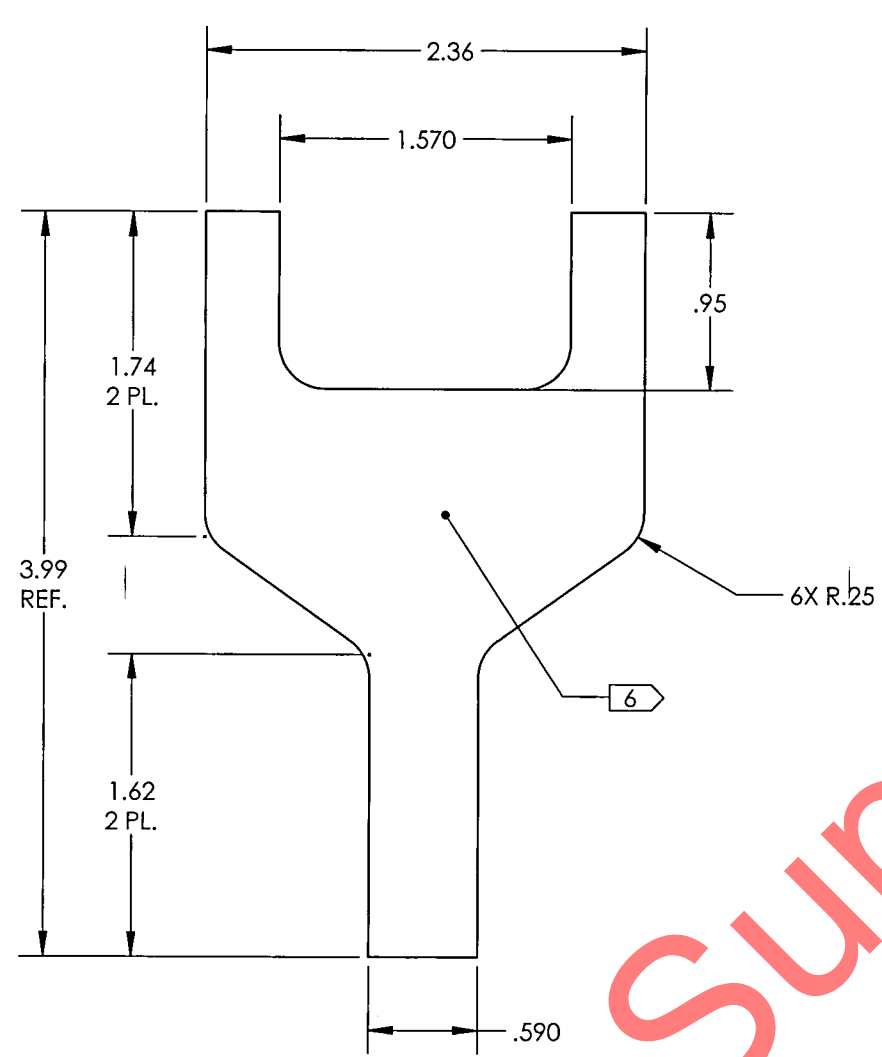
8 7 6 5 4 3 2 1

D

C

B

A



D

C


B

A

RBEM623U1002102-1 LIFTING CLEVIS

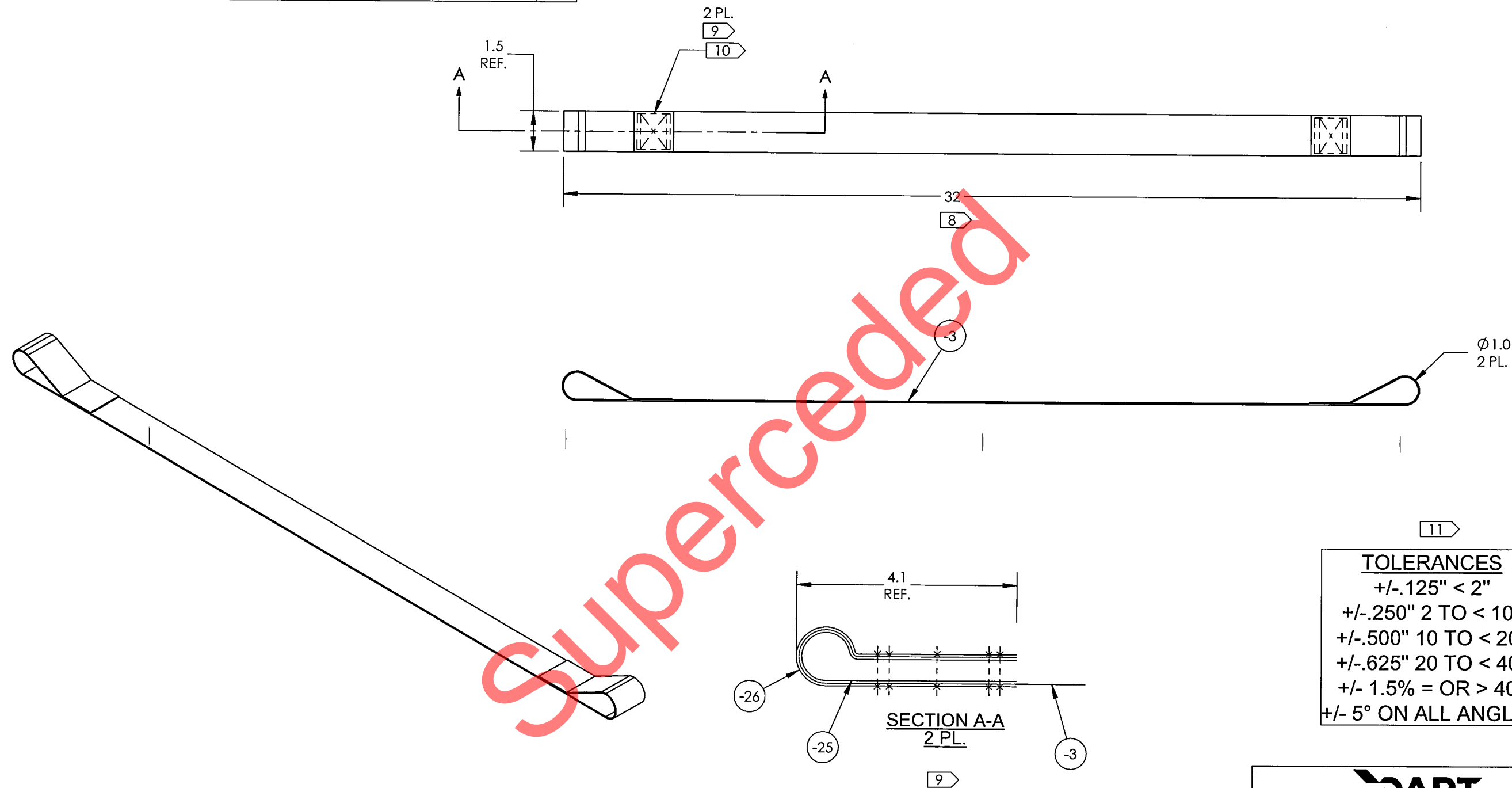
- NOTES:
- 1) MATERIAL: AISI 1018/1020 CR
 - 2) HEAT TREAT: N/A
 - 3) FINISH: POWDER COAT YELLOW PROTECH# HS112Y12
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 - 6) IDENTIFICATION: INK STAMP P/N

UNDER REVIEW
URF 17-778 VM

 <small>Hawkesbury, Ontario, Canada</small>				
TITLE LIFTING CLEVIS				
DWG NO. RBEM623U1002102-1			REV C	
DESIGN BY:	VM 10/6/2017	<div><div>.XXX ± .005 FRACTIONS ± 1/8</div><div>.XX ± .01 ANGLES ± 5°</div><div>.X ± .1 SURFACES = 125</div><div>1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED</div><div>2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</div><div>3. DIMENSIONAL LIMITS APPLY AFTER PLATING</div></div>		
DRAWN BY:	VM 11/28/2017			
CHECKED:	WM 11/28/2017			
MFG. APPR:	DP 11/29/2017			
APPROVED:	WM 11/29/2017			
DATE:	11/28/2017			
SCALE:	NTS	WEIGHT:	0.485 LBS	SHEET 2 OF 7
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	TITLE	PG
-3	1	RBEM623U1002102-3	STRAP	4
-25	2	RBEM623U1002102-25	WEB SLING PROTECTORS INNER	5
-26	2	RBEM623U1002102-26	WEB SLING PROTECTORS OUTER	6



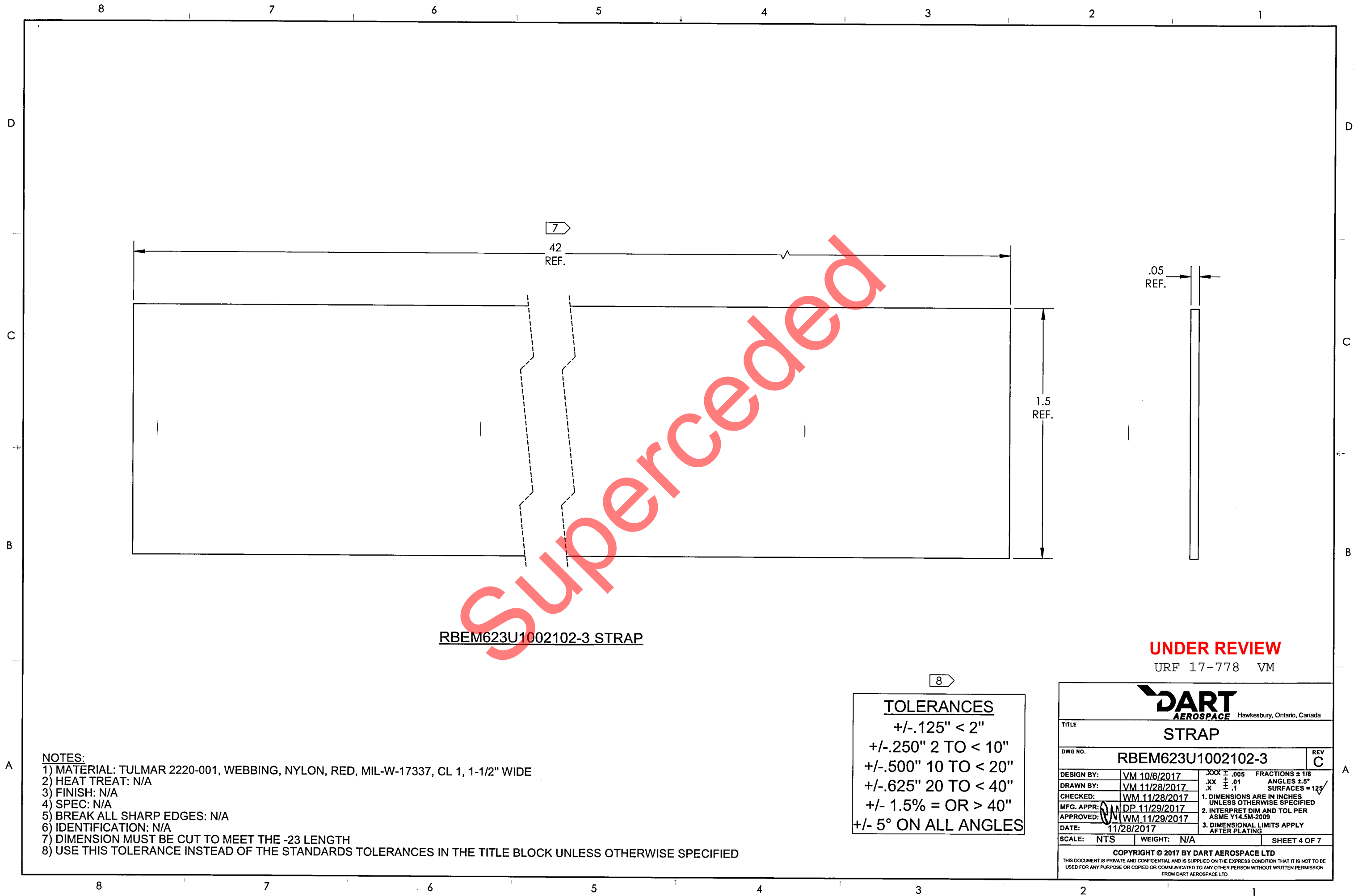
NOTES:
1) MATERIAL: RBEM623U1002102-23 STRAP ASSY SUPPLIED BY TULMAR 87345-001
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) SAFETY CERTIFICATE REQUIRED FOR SWL OF 75 LBS
8) FINAL LENGTH OF SEWN STRAP
9) USE TULMAR 2544, THREAD, NYLON, RED, A-A-59826, TY2, CLA, SIZE F, FOR ALL SEWING
10) 1-1/4 x 1-1/4 FLAG
11) USE THIS TOLERANCE INSTEAD OF THE STANDARDS TOLERANCES IN THE TITLE BLOCK UNLESS OTHERWISE SPECIFIED

RBEM623U1002102-23 STRAP ASSY

UNDER REVIEW
URF 17-778 VM

TOLERANCES
+/- .125" < 2"
+/- .250" 2 TO < 10"
+/- .500" 10 TO < 20"
+/- .625" 20 TO < 40"
+/- 1.5% = OR > 40"
+/- 5° ON ALL ANGLES

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE STRAP ASSY	
DWG NO. RBEM623U1002102-23	REV C
DESIGN BY: VM 10/6/2017	XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 11/28/2017	XX ± .01 ANGLES ± 5°
CHECKED: WM 11/28/2017	X ± .1 SURFACES = 125
MFG. APPR: DP 11/29/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: WM 11/29/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 11/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 3 OF 7	
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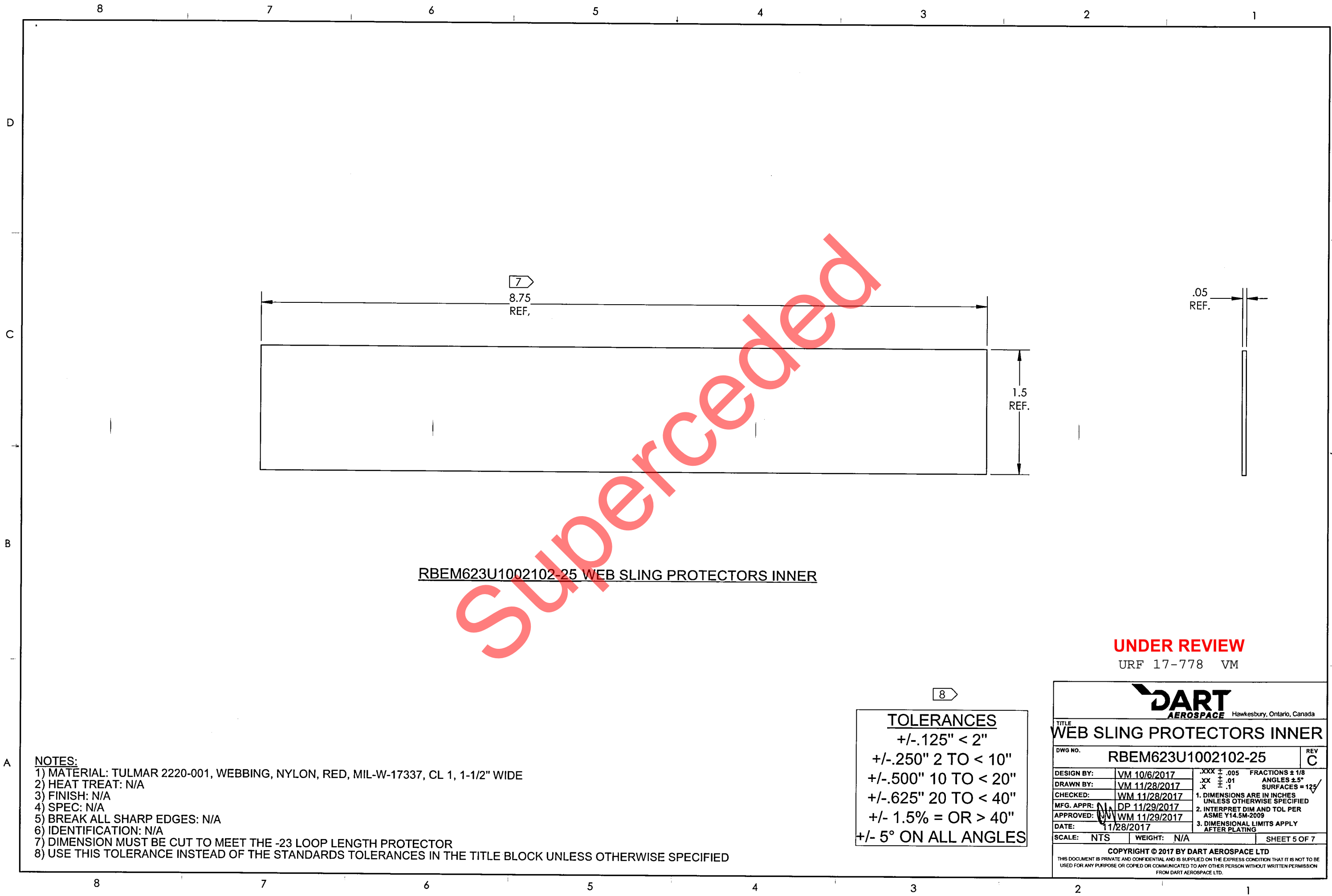
RBEM623U1002102-3 STRAP

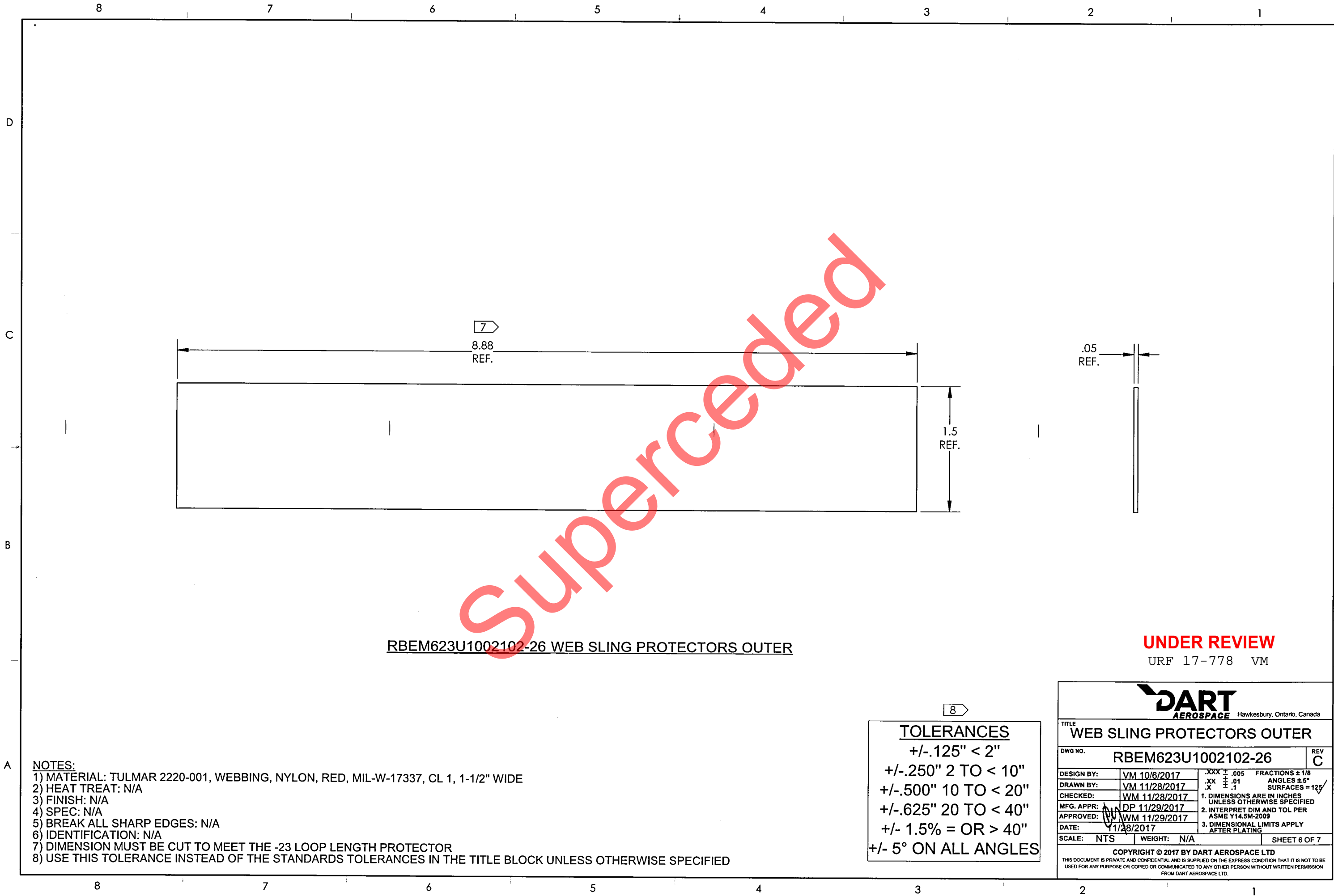
UNDER REVIEW
URF 17-778 VM

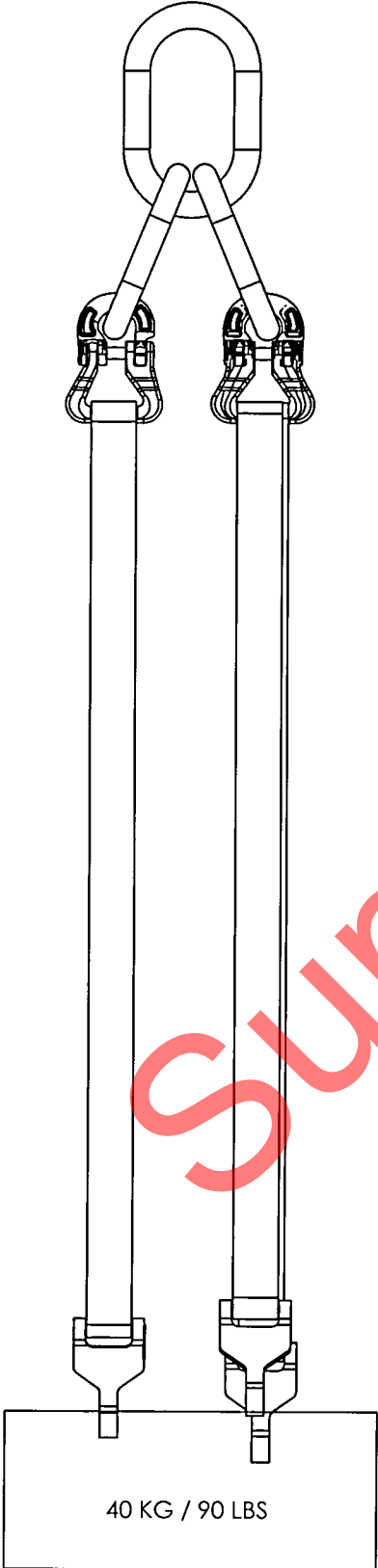
TOLERANCES	
+/- .125" < 2"	
+/- .250" 2 TO < 10"	
+/- .500" 10 TO < 20"	
+/- .625" 20 TO < 40"	
+/- 1.5% = OR > 40"	
+/- 5° ON ALL ANGLES	

- NOTES:
- 1) MATERIAL: TULMAR 2220-001, WEBBING, NYLON, RED, MIL-W-17337, CL 1, 1-1/2" WIDE
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) DIMENSION MUST BE CUT TO MEET THE -23 LENGTH
 - 8) USE THIS TOLERANCE INSTEAD OF THE STANDARDS TOLERANCES IN THE TITLE BLOCK UNLESS OTHERWISE SPECIFIED

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE STRAP	
DWG NO. RBEM623U1002102-3	REV C
DESIGN BY: VM 10/6/2017	XXX ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 11/28/2017	XX ± .01 ANGLES ± 5°
CHECKED: WM 11/28/2017	X ± .1 SURFACES = 125
MFG. APPR: DP 11/29/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: WM 11/29/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 11/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
SHEET 4 OF 7	
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INSPECTION & TESTING PROCEDURES FOR THE RBEM623U1002102, UPPER STOPS AND FAIRING SLING. THIS SLING IS DESIGNED FOR HOISTING AND INSTALLING/REMOVING THE H175 COWLING. THIS SLING ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USING!

FIRST ARTICLE WEIGHT TEST

- 1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT TEST WEIGHT OF 40Kg / 90 LBS.
- 2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTION, DISTORTION OR DAMAGED/FRAYED STRAPS.
- 3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR STRESS CRACKS, BENDING, DISTORTIONS OR DAMAGED/FRAYED STRAPS.

INSPECTOR: _____
TESTER: _____
S.N.: _____
DATE: _____

UNDER REVIEW
URF 17-778 VM

 DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE SWASHPLATE SLING			
DWG NO. RBEM623U1002102			REV C
DESIGN BY:	VM 10/6/2017	.XXX ± .005	FRACTIONS ± 1/8
DRAWN BY:	VM 11/28/2017	.XX ± .01	ANGLES ± 5°
CHECKED:	WM 11/28/2017	X ± .1	SURFACES = 125
MFG. APPR:	DP 11/29/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	WM 11/29/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	11/28/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
SHEET 7 OF 7			
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